

Work Order ID 148141

148141

Page 1

Monday, June 27, 2016 11:23:18 AM

Item ID: D4853-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Bracket (Replaces P/N G13013-1)
 Start Date: 6/27/2016 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 7/20/2016 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: JUN 27 2016 Date: DAS 13 9-89 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4853	A								DAS 13 9-89
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Issue P/O to Metec : <u>32840</u> Machine as per dwg C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.08							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control									

24 JUN 27 2016 DAS 13 9-89

24x 80/6-7-13

(24) JUL 15 2016 DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																							
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Work Order ID 148141***148141***

Page 2

Monday, June 27, 2016 11:23:18 AM

Item ID: D4853-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Top Bracket (Replaces P/N G13013-1)

Start Date: 6/27/2016 Start Qty: 24.00

24

Cust Item ID:

Required Date: 7/20/2016 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00				<u>24</u>			<u>2016/07/18</u> <u>BEB</u>
140									
HandFinish	Memo	0.20							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							<u>DAS 34 9-89</u>
150						<u>24</u>	<u>0</u>	<u>1607-20</u>	
QC	Memo	0.04							
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							<u>DAS 34 9-89</u>
160						<u>24</u>	<u>0</u>	<u>1607-20</u>	
Powdercoat	Memo	0.04							
Powder Coating	START TIME: <u>7:25</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>7:55</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
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Work Order ID 148141

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Page 3

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Item Name: Top Bracket (Replaces P/N G13013-1)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									DAS 38 9-89
QC	Memo	0.04							JUL 2 0 2016
Quality Control									
180	Identify as per dwg & Stock Location: <u>SS17</u>	0.00							
180									
Packaging	Memo	0.04							JUL 2 1 2016
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									DAS 21 9-89
QC	Memo	0.40							JUL 2 2 2016
Quality Control									

DAS
21
9-89
JUL 2 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, June 27, 2016 11:23:17 AM

Page 1

Work Order ID: 148141

148141

Parent Item: D4853-1

D4853-1

Parent Item Name: Top Bracket (Replaces P/N G13013-1)

Start Date: 6/27/2016

Required Date: 7/20/2016

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 13-07-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No				f	224.6140		1.894737			
D2423									**			AUG 02 2016	DAS 13
Lug Extrusion													13-09

Location

Loc Qty

Loc Code

Metec

224.6139767

127892

38.9964647

131451

185.617512

D4853-1P

Purchased

No

Each

0.0000

24

D4853-1P

Top Bracket (Replaces P/N G13013-1)

24K 16-7-13 SP

DQA: _____ Date: _____

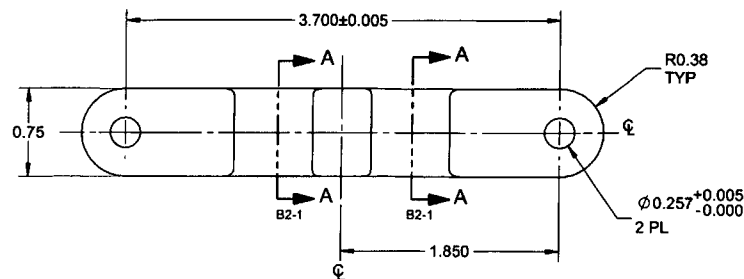


WORK ORDER NON-CONFORMANCE / UPDATE

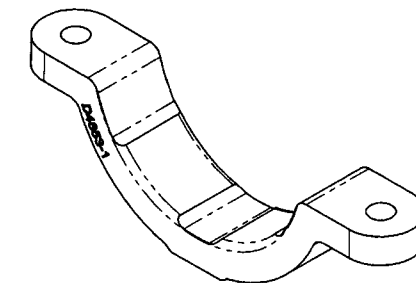
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Work Order update only ☐

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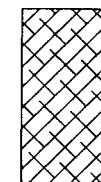
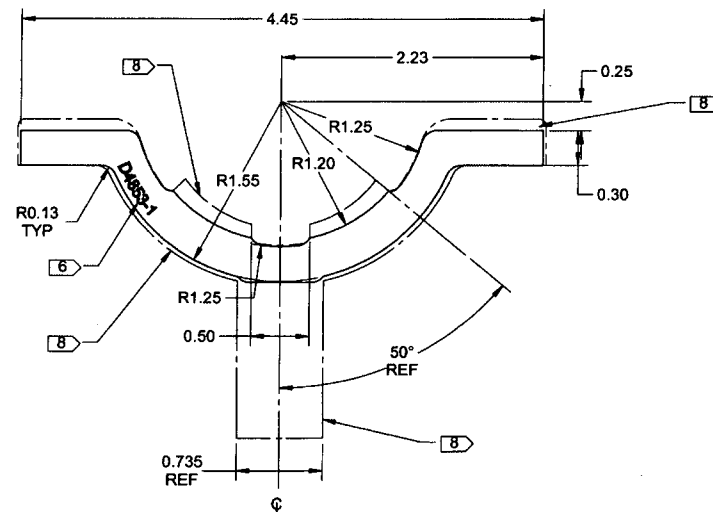


DAS
13
9-89



JUN 27 2016

W10: 148/41



R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
SCALE 2X
D6-1

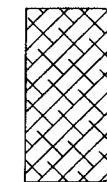
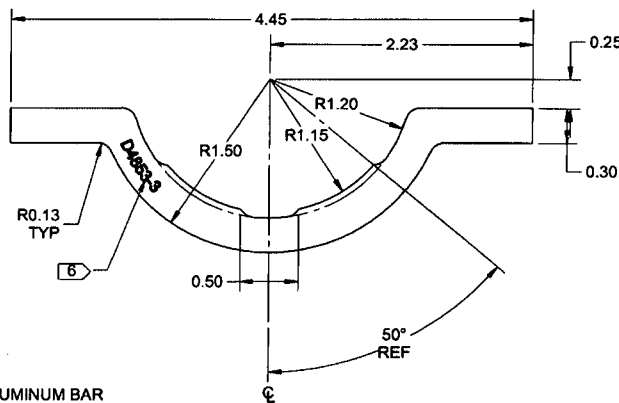
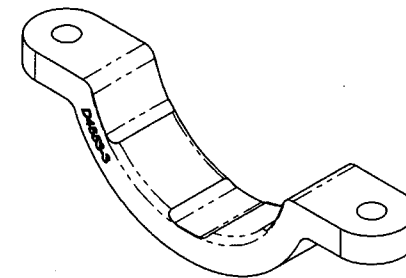
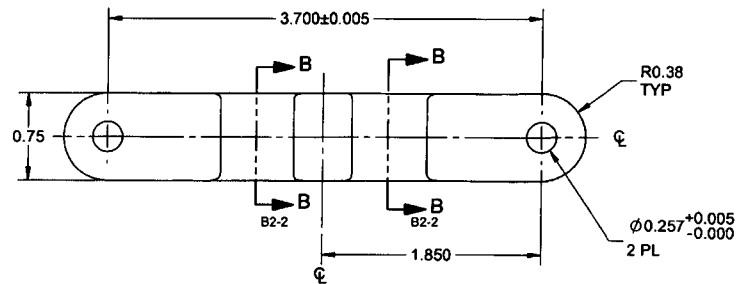
RELEASED
2013-07-16
MR

NOTES:

- 1) MATERIAL: MAKE FROM D2423 LUG EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.12 lbs
- 8) MACHINE TO SIZE
- 9) REPLACES GENEVA P/N G13013-1

D4853-1 TOP BRACKET

A		NEW ISSUE		13.05.15	
REV.		DESCRIPTION		BY DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D4853		SHEET 1 OF 4	
APPROVED		TITLE		SCALE	
DE APPR.		TOP BRACKET		NTS	
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SECTION B-B
SCALE 2X
D6-2

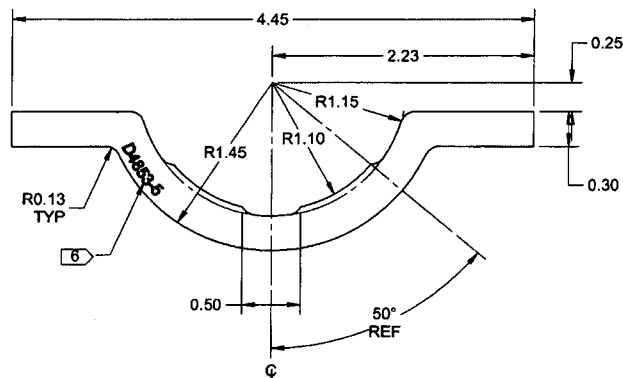
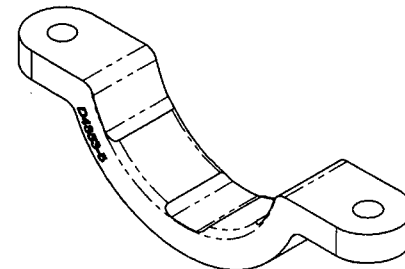
RELEASED
2013-07-16

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010 ± 0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.12 lbs
- 8) REPLACES GENEVA P/N G13013-5

D4853-3 TOP BRACKET

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4853	REV. A
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOP BRACKET	NTS
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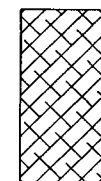
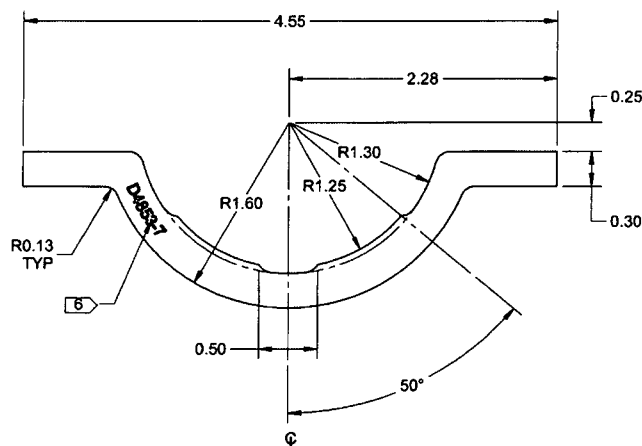
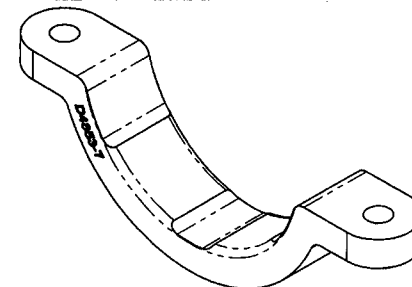
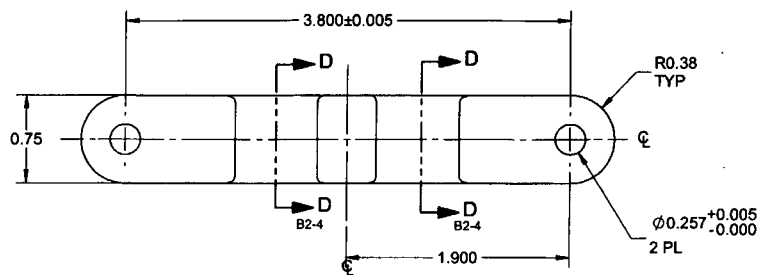
SECTION C-C
SCALE 2X
 D6-3

RELEASED
2013-07-16

D4853-5 TOP BRACKET

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.11 lbs
- 8) REPLACES GENEVA P/N G13013-7

DESIGN	<i>OS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4853 TITLE TOP BRACKET SCALE NTS	REV. A
DRAWN	<i>OS</i>		SHEET 3 OF 4
CHECKED	<i>OS</i>		
MFG. APPR.	<i>21</i>		
APPROVED	<i>OS</i>		
DE APPR.	<i>OS</i>		
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R0.06 MIN - R0.10 MAX
2 PL

SECTION D-D
SCALE 2X
D6-4

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010 ± 0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.12 lbs
- 8) REPLACES GENEVA P/N G13013-9

D4853-7 TOP BRACKET

RELEASED
2013-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4853	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOP BRACKET	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32840**

Purchase Order Date 6/27/2016

PO Print Date 6/28/2016

Page Number 1 of 2

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

JUN 28 2016

Contact Name

Vendor Phone

613 678 3957

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3235-1P	Lug	7/14/2016 Yes 7/14/2016	FN	50.00 Each	\$15.00	\$750.00

AS PER DWG D3235 REV. A
B148140
ALODINE AND PAINT AS PER QS1005

Line Total: \$750.00

2 D4853-1P

Top Bracket (Replaces P/N
G13013-1)

7/20/2016

Yes

7/20/2016

24.00

Each

\$23.00

\$552.00

AS PER DWG D4853 REV. A
B148141

Line Total: \$552.00

SP16-7-13

Note:

6/28/2016



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21305
Date: Jul 13, 2016
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 32840	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: Jul 13, 2016

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3235-1 Mounting Lug Alodine and Paint as per QSI 005	Each	50		50
D4853-1P Top Bracket (Replaces P/N G103013-1) ✓	Each	24	24 ✓	
D3404-1 GHW/Lug, as per drawing D3404-1 Rev C Alodine and Paint as per QSI 005	Each	80		80

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by SP/67-13

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
24	D4853-1	Lug	21305

MATERIAL: supplied by DART B131451

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, July 13, 2016